

## ABSTRACT

A work chucking/inserting device for chucking and inserting a work into an insertion hole (cylinder bore) in alignment with the hole, including three or more chuck fingers, the chuck fingers being arranged in circumferentially spaced positions and mounted for advancing and retracting radially. Inner surfaces of the chuck fingers serve as chuck surfaces for chucking the work, and outer surfaces of the chuck fingers are tapered at least at tip end portions radially inward toward the tips for contact with an inlet of the insertion hole. The work chucking/inserting device further includes a tracer mechanism which causes the axis of a conical surface defined by the outer surfaces of the chuck fingers to become aligned with the axis of the insertion hole when the outer surfaces of the chuck fingers contact the inlet of the insertion hole. A pushing mechanism is included for pushing the work toward the insertion hole. The work chucking/inserting device can handle various sizes of workpieces with a simple structure, within a short time and with high working efficiency.